

Work Order ID 67609

Monday, March 28, 2011 2:29:38 PM



Page 1

Item ID: D3296-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Assembly

Start Date: 3/28/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11/03/28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3296

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate & assemble as per Dwg D3296.

Transfer drill using DT8470 & DT9521

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

120

0.00



Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Powdercoat

Memo

0.00

Powder Coating

START TIME:

DOVEN TEMPERATURE:

FINISH TIME:

11:15

3200

11:45

M115128

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Monday, March 28, 2011 2:29:38 PM



[REDACTED]

Abstract

Abstract

1. The first group of respondents was composed of 100 individuals who were randomly selected from the telephone book of the city of Chicago. The second group was composed of 100 individuals who were randomly selected from the telephone book of the city of Chicago. The third group was composed of 100 individuals who were randomly selected from the telephone book of the city of Chicago. The fourth group was composed of 100 individuals who were randomly selected from the telephone book of the city of Chicago. The fifth group was composed of 100 individuals who were randomly selected from the telephone book of the city of Chicago. The sixth group was composed of 100 individuals who were randomly selected from the telephone book of the city of Chicago. The seventh group was composed of 100 individuals who were randomly selected from the telephone book of the city of Chicago. The eighth group was composed of 100 individuals who were randomly selected from the telephone book of the city of Chicago. The ninth group was composed of 100 individuals who were randomly selected from the telephone book of the city of Chicago. The tenth group was composed of 100 individuals who were randomly selected from the telephone book of the city of Chicago.

1. **Introduction**

2. **Background**

3. **Methods**

4. **Results**

5. **Conclusion**

6. **References**

7. **Appendix**

8. **Table 1**

9. **Table 2**

10. **Table 3**

11. **Table 4**

12. **Table 5**

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229. <

Customer:

[illegible]

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

Date:

**Insp.
Stamp**

00000000000000000000000000000000

0.00

6 PR 11-5-10.

...the ...

0.00

Assemble as per Dwg D3296

511/05/11 (6)

0.00

Sulast

46

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 67609

Monday, March 28, 2011 2:29:38 PM



Page 3

Item ID: D3296-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Assembly

Start Date: 3/28/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 218

0.00



Packaging

Memo

0.00

Packaging

11/5/11 8/60

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/12 10

MK

11-05-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Monday, March 28, 2011 2:29:44 PM

Page 1

Work Order ID: 67609

Parent Item: D3296-041

Parent Item Name: Door Assembly



Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C05.10.14 Added step 14 KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-7 		Manufactured	No			100	Each	0.0000	1	6			
Hinge 14.0"													
D3161-9 		Manufactured	No			100	Each	2.0000	1	6			
Hinge 17.0"													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST037				2					
				65098				2					
D3296-1 		Manufactured	No			100	Each	8.0000	1	6			
Door Panel													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST186				8					
				65083				2					
				66192				6					
D3296-3 		Manufactured	No			100	Each	6.0000	1	6			
Door Panel													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST196				6					
				66191				6					

B68487

3/31/05/11

3/31/05/11

B68894 (4X)

3/31/05/11

2

3/31/05/11

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, March 28, 2011 2:29:44 PM

Page 2

Work Order ID: 67609

Parent Item: D3296-041

Parent Item Name: Door Assembly

Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 6.00

Required Qty: 6.00

MS20470AD4-6 Purchased No

100 Each

1,762.000

1

6



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

1762

116391

1762

140

Each

245.0000

1

6

AN960JD6

NAS1149DN632J Purchased

No



Washer

4D M116978 (62)

Location

Loc Qty

Loc Code

ST347

245

104537

245

140

Each

11.0000

1

6

D2137

Manufactured

No



Decal - No Step

Location

Loc Qty

Loc Code

GA

11

62071

10

65121

1

140

Each

1.0000

1

6

D2419

Manufactured

No



Handle

Location

Loc Qty

Loc Code

GA

1

63423

1

140

f

480.0000

0.3333

1.9998

D2462

Manufactured

No



Seal

Location

Loc Qty

Loc Code

ST404

480

48530

480

1.9998

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, March 28, 2011 2:29:45 PM

Work Order ID: 67609



Parent Item: D3296-041



Parent Item Name: Door Assembly

Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 6.00

Required Qty: 6.00

D2728-1 Manufactured No

140

Each

0.0000

0

0



Dart Logo label

MS20470AD4-4

Purchased No

140

Each

2,678.000

25

150



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

2678

116188

2317

116391

361

Handwritten: 3/31/05/11
150

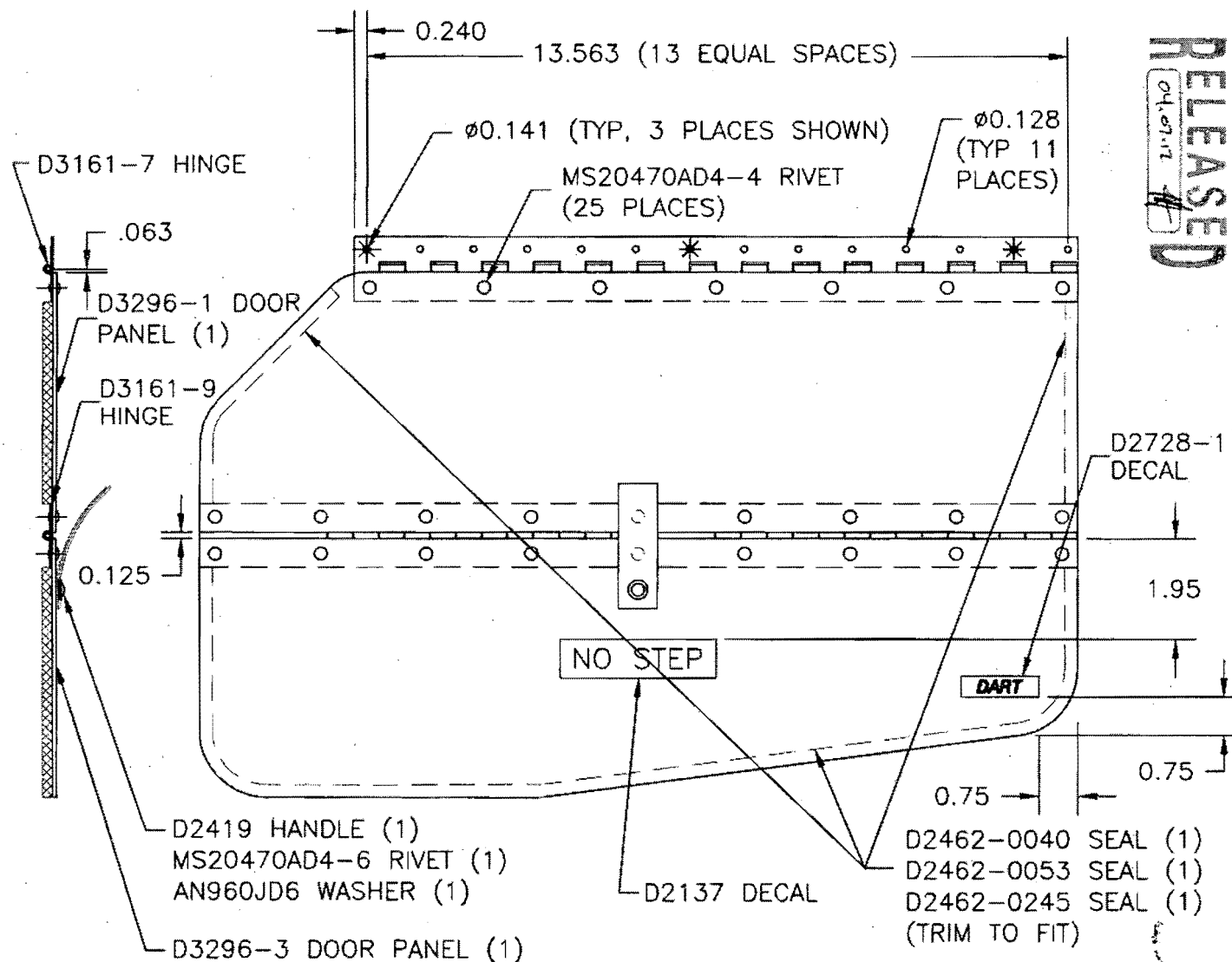
W/O:		WORK ORDER CHANGES					
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D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 17609



DESIGN	DRAWN BY	DART AEROSPACE LTD
04.06.28	04.06.28	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3296
DATE	TITLE	REV. A
04.06.28	DOOR ASSEMBLY	1 OF 2
A	NEW ISSUE	SCALE 1:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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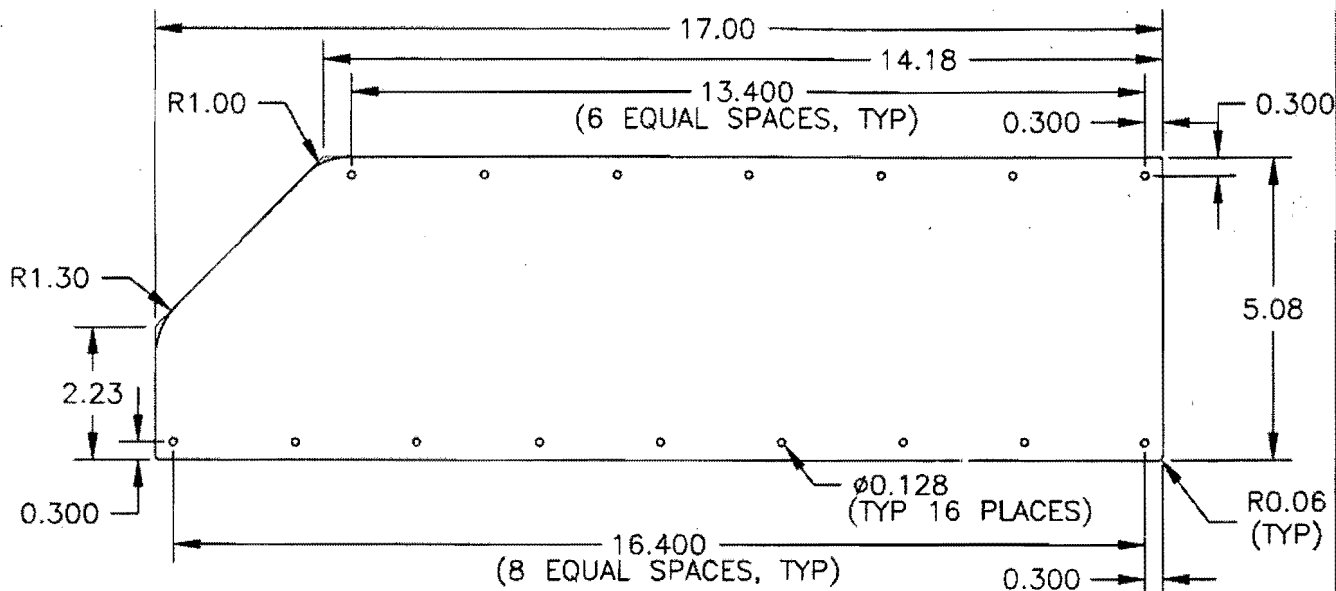
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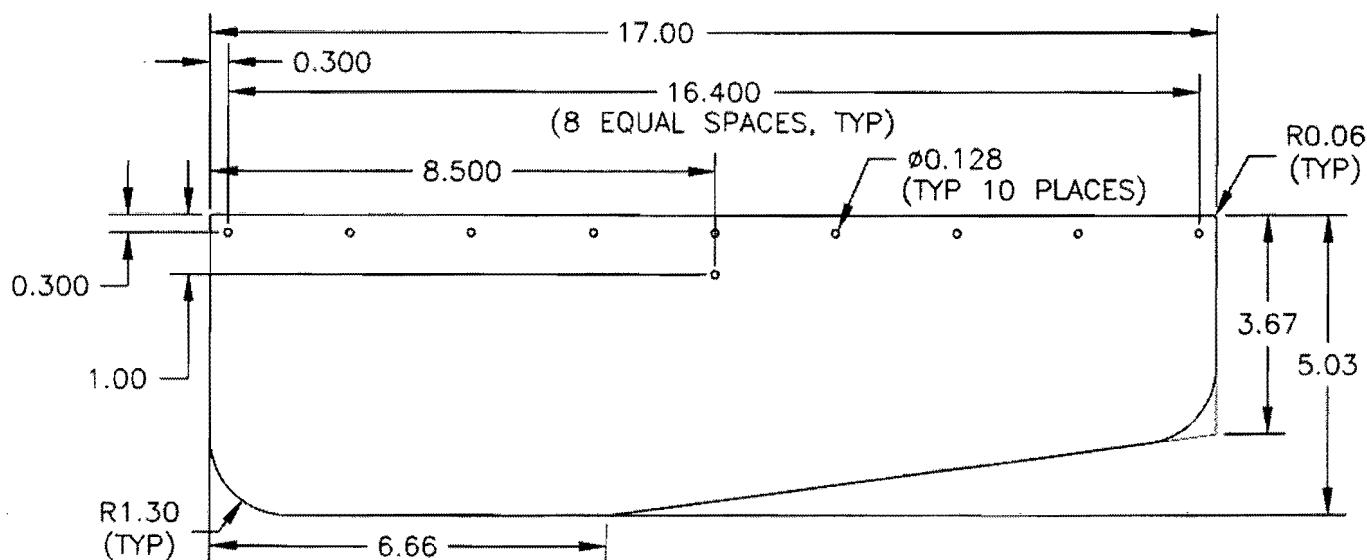


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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12 *#*

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